

Work Order ID 84564

84564

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May-16-12 11:50:14 AM

Item ID:	D500-560-041	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Cargo Mirror Assembly, 6 inch Round					
Start Date:	5/16/12	Start Qty:	1.00	*1*	Cust Item ID:	
Required Date:	5/17/12	Req'd Qty:	1.00	*1*	Customer:	
Reference:	REWORK- ECN1195P					
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev D								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels as per PPP D500-560-041 CHG005								
110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	PULL FROM HK TO UPDATE TO CHG005:								
	1 X D500-560-041 B33791								
	DISASSEMBLE MIRROR ASS'Y								
	DISCARD/SCRAP D2010-103 ARM AND D2057 PLUG (THESE ARE OLD REV'S)								
	REASSEMBLE WITH NEW								
	1 X D2010-103 B 69620 REV D								
	1 X D2057 B 71880 REV C								
	Assemble as per drawing D500-560								
	PAGE 8- BLUE FILE								

12-6-13
FF
12-06-05

NA was on the arm D2010-103

Work Order ID 84564***84564***

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Mgy-16-12 11:50:14 AM

Item ID: D500-560-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Mirror Assembly, 6 inch Round

Start Date: 5/16/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/17/12 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK- ECN1195P

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Packaging Packaging	Packaging Memo REPACKAGE PER PPP USING NEW B/N NEW LABELS AND PAPERWORK REQ'D Identify and pack for shipping as per PPP D500-560-041 Location: <u>42</u> PPP Rev: _____	0.00 0.00				<u>12</u>		<u>12/6/13</u>	
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>12/6/14</u> ME 12-06-13

Picklist Print

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Work Order ID: 84564

Parent Item: D500-560-041

Start Date: 5/16/12

Required Date: 5/17/12

Parent Item Name: Cargo Mirror Assembly, 6 inch Round

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E03.10.15Reformat; Removed D2057KJ/RF
IPP Rev:F 08-05-27 as per ECN1195p DD verified by:EC IPP Rev:G 10.04.22 chg route seq
DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2010-103 Mirror Arm, 500		Manufactured	No				Each	2.0000		1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST220		2							
				69620		2							
D2057 Plug		Manufactured	No				Each	25.0000		1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		25							
				71888		5							
				75070		20							
D500-560-041 Cargo Mirror Assembly, 6 inch Round		Manufactured	No				Each	4.0000		B33791 1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG042		4							
				76018		2							
				81704		2							

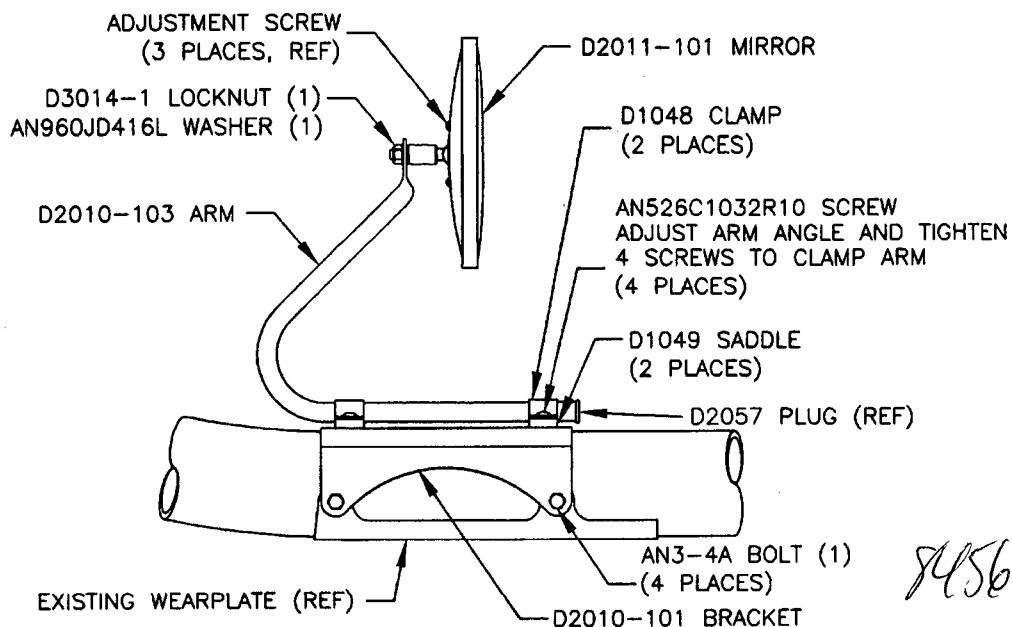


Figure 2: Installation of D500-560-041 Cargo Mirror Assembly

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-560-041 Cargo Mirror Assembly	1.0 lb 0.45 kg	-45 in -1.14 m	-45 lb-kg -0.51 m-kg	24 in 0.61 m	24 in-lb 0.27 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D500-560-041	CARGO MIRROR ASSEMBLY
1	D2011-101	MIRROR
1	*D3014-1	LOCKNUT
1	*AN960JD416L	WASHER
2	D1048	CLAMP
2	D1049	SADDLE
1	D2010-101	BRACKET
1	D2010-103	ARM
4	AN3-4A	BOLT
4	AN526C1032R10	SCREW (OR AN526-1032R10)

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

84564

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14
-33791
@19004

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 08.10.28	Job No.: 00569	ADR Yes/No: <input checked="" type="checkbox"/> NO	ADR Date: N/A	ECN #: 08- 548
Product No.: D2011-101	Created By: <i>MB</i>	Approved By: <i>MB</i>		
Product Name: MIRROR ASSEMBLY		Checked By: <i>MB</i>	General Manager Approval:	

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	<i>LL 08.11.04</i>
Production Engineering Coord	Y	DD	<i>DD 08.11.04</i>
Production Document Control	Y	JLD	<i>JLD 08.11.03</i>
Customer Technical Support	N		

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	N		
Marketing	N		
Customer Order Processing	N		

Reason for Change:

Documents Affected:

RELEASE D2011 RE.V G AND D2829 REV. B

PARTS MUST COMPLY

☐

PREVIOUS PARTS SATISFACTORY

☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	MB		<i>08.10.30</i>
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		<i>08.10.30</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	N	KJ		
10	Update Controlled PDF Files	Y	KJ		<i>08.10.30</i>
11	Update Master Document List (MDL)	N	KJ	<i>NO MDL</i>	
12	Update Document Record (DR)	Y	MB	<i>MB/ST - SEE BELOW</i>	<i>08.10.30</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N	KJ	AS REQUIRED. N/A	<i>08.10.30</i>
16	Update / Verify ARC Database	N	KJ	AS REQUIRED. N/A	<i>08.10.30</i>
17	Create / Update Change Record Form	Y	KJ	SEE BELOW.	<i>08.10.30</i>
18	Create / Update PPP's	Y	KJ	SEE BELOW.	<i>08.10.31</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		<i>08.10.30</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		<i>08.10.30</i>
22					
23					

Description / Action:

D206-558-041/-043 NOW @ CHG 008
D500-560-041 NOW @ CHG 006
D350-561-041/-043 NOW @ CHG 006
D350-561-045/-141/-143 NOW @ CHG 002
D076-612-011 NOW @ CHG 004
D119-696-011/-013 NOW @ CHG 004
D044-715-011 NOW @ CHG 003
D022-716-011 NOW @ CHG 003

560	F	/	No
561	H	/	No
612	G	/	No
696	D	/	D
715	E	/	No
716	E	/	No

ECN Verified & Complete: *MB*

Date: *08/11/04*

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 08.05.26	Job No.: TBP	ADR Yes/No: TBP	ADR Date: 11/11	ECN #: 1195P
Product No.: D044-715, D022-716, D500-560		Created By: TBP	Approved By: [Signature]	
Product Name: MIRROR		Checked By: [Signature]	General Manager Approval:	

Distribution	Reqd	Resp	Received
Production Manager	Y	LL	
Production Engineering Coord	Y	DD/EC	
Director Quality Assurance			
Customer Order Processing			

Distribution	Reqd	Resp	Received
Customer Technical Support	Y	DSTOW	12.05.26
Marketing	Y	SW	8W 08.05.26

Reason for Change:
Mirror arm cracking - use thicker wall tubing on D2010-103/-104

Documents Affected:
D2010 Rev. D PRELIM
D2057 Rev. C PRELIM

#	Engineering Actions	Reqd	Resp	Notes	Complete
1	Required Documents/Drawings Under Review	Y	PH		08.05.27
2	Update Blue/Pink/DSI Folder and Electronic Files	N			
3	Update D-Part/M-Drawing/DSI/DEO Master Binders	N			
4	Update Grey Project Binder	N			
5	Move Electronic Files	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Create/Update Change Record Form	Y	KJ	See below	08.05.26
9	Create/Update PPP's	Y	KJ	See below	08.05.26
10	Update Controlled PDF Files	N			
11	Notify TC/FAA of Change	N			
12	Update QSI 021 and/or STC Approval List	N			
13	Update Product Development Summary	N			
14	Update Accpac Database	N			
15	Update Access (ARC) Database	N			
16	Update/Verify ARC	N			
17	Update Paperwork Kits in Production	N			
18	Update Qpulse/Laminated Dwgs	N			
19	Update Product Compatability Matrix	N			
20	Create Eurocopter Form (FEE)	N			
21					

#	Production Actions	Reqd	Resp	Notes	Complete
22	Create/Update Coss IPP/BOM	Y	DD/EC	As required	
23	Update FAI Sheets	Y	DD/EC	As required	
24	Create/Update CNC Programs	Y	DD/EC	As required	
25	Create/Update Tooling	N			
26	Red Tag Stock (Specify)	N			
27	Rework/Scrap Current Production and/or Stock	Y	LL	Scrap D2010-103/-104 made I.A.W. Rev. C or earlier	
28	Update Paperwork Kits in Stock	N			
29	Create/Update MPP	N			
30					

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
31	Notify Previous Customers	N			
32	Notify Eurocopter France	N			
33					

Description / Action:
For kits that contain parts reworked to D2010 Rev. D and D2057 Rev. C:
CHG number will be D044-715-011 CHG 002, D022-716-011 CHG 002, D500-560-041 CHG 005

Date: Monday, 7/30/2007 1:53:54 PM
 User: Kiri Johnston

Process Sheet

35

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 500 MIRROR ASSEMBLY
 Job Number : 33791
 Estimate Number : 11970
 P.O. Number : Part Number : D500560041
 This Issue : 7/30/2007 S.O. No. : Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : SMALL / MED FAB Drawing Revision : N/A
 Previous Run : 33193 Material :
 Written By : Due Date : 8/30/2007 Qty: 10 Um: Each
 Checked & Approved By : 07.07.30
 Comment : Est Rev E 03.10.15 Reformat; Removed D2057 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D500-560-041 CHG004

07.07.31
 2 40657

2.0 D1048 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch
 2 D1048 Clamp B29769

mf

3.0 D1049 Saddle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch
 2 D1049 Saddle B29770

mf

4.0 D2010101 Mirror Bracket 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2010-101 Bracket B33914 x 8mx, B24060 x 2mx.

mf
 07-01-06

Date: Monday, 7/30/2007 1:53:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 500 MIRROR ASSEMBLY

Job Number: 33791

Part Number: D500560041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D2010103

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2010-103 Bracket

Batch

B 35204 x 2m, B 33915 x 8mx

mf

6.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2011-101 Mirror

Batch

B 33916

mf

7.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN526C1032R10 Screw

M15072

mf

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per drawing D500-560

mf 02-11-06

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

contop
4/4/06 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

11.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

Batch

M103287 25X M103641 15X

07/11/06 (4)

Date: Monday, 7/30/2007 1:53:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 500 MIRROR ASSEMBLY

Job Number: 33791

Part Number: D500560041

Job Number:



Seq. #:

Machine Or Operation:

Description:

4 AN3-4A Bolt

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 7/11/07

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D500-560-041

Location:

PPP Rev:

D

AS 07/11/07

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.07

Job Completion



U 07-11-07

Work Order ID 84564

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Item ID: D500-560-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cargo Mirror Assembly, 6 inch Ro

Start Date: 5/16/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/17/12 Req'd Qty: 1.00

1

Customer:

Reference: REWORK- ECN1195P

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev D

ML5 12/06/08

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D500-560-041 CHG005

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

PULL FROM HK TO UPDATE TO CHG005:

1 X D500-560-041 B33791

DISASSEMBLE MIRROR ASS'Y

DISCARD/SCRAP D2010-103 ARM AND D2057 PLUG (THESE ARE OLD REV'S)

REASSEMBLE WITH NEW

1 X D2010-103 B *69675* REV D

1 X D2057 B *71300* REV C

Assemble as per drawing D500-560

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NA was on the CHG D500-560

Part Number D 500-560-041
Description 500' Miner

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Chg.	Date	By	Relevant Documents
002	99.06.07	KE	per Document Record DR-0560-560 rev A
003	01.04.25	DS	per DR-D500-S60 rev. B See D2011 Rev. D
004	03.01.06	DS	D2011-101 PER D2011 REV. E1
005	08.05.26	JH	D2010 Rev.D, D2057 Rev.C (ECN 1195P)
006	08.10.30	HJ	REVISED D2011 Rev. G, D2829 Rev.B (ECN 08-548)